**Abrasive Products for Grinding and Finishing of Hard Coatings**

Convert your wheel grinder into a high performance machine capable of using superabrasive belts - and increase your capacity up to 3X.

**Process Recommendations and Examplary Results**

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
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<th>CAM Center</th>
<th>CAM Center</th>
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<tr>
<td>3M™ Trizact Diamond Cloth 663FC</td>
<td>Abrasive Belt</td>
<td>Grinding, Polishing, Finishing</td>
<td>900 Bush Av.</td>
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</tbody>
</table>

**Contact Wheel Specifications**

- **Contact Wheel Materials**
  - Aluminum Oxide
  - Tungsten Carbide
  - Thermal Spray Coatings:
    - Chrome Oxide
    - Nickel Based
    - Chrome Carbide
    - Tungsten Carbide

**Abrasive Belt Specifications**

- **Abrasive Speed**
  - 0.03-0.1
- **Abrasive Support**
  - 0.0006
- **Abrasive Grade**
  - A10
- **Extra Abrasive Support**
  - A80
- **Abrasive Thickness**
  - 0.07 inch/rev
- **Traverse Rate**
  - 1/10-1/4 inch/rev
- **Contact Wheel Oscillation**
  - 1/8 inch/rev
- **Contact Wheel Pressure**
  - 1/8 inch/rev
- **Workpiece Speed**
  - 1 inch/min
- **Suction Rate**
  - 0.0008

**Recommended Coatings**

- **Coatings**
  - Chrome Carbide
  - Tungsten Carbide
  - Ceramic Oxide
  - Diamond
  - Trizact
- **Suction Coating**
  - 3M™ Trizact Cloth Belt 966F
  - 3M™ Cloth Belt 966F

**Operating Conditions**

- **Head Traverse Speed**
  - 33/245
- **Head Motor Load**
  - 45/312
- **Contact Wheel Oscillation**
  - 150-350
- **Suction Rate**
  - 10-20

**Expected Results**

- **Improved Performance**
  - Increased production, ease of use, lower costs, improved quality of surface finishes and workpiece integrity.
- **Reduced Costs**
  - Reduced labor costs, reduced machine downtime, reduced product scrap.
- **Enhanced Productivity**
  - Increased productivity, reduced cycle times, reduced labor costs.

**Additional Benefits**

- **Eco-Friendly**
  - Reduced waste generation, reduced energy consumption, reduced water usage.
- **User-friendly**
  - Easy to use, intuitive controls, simple operation.

**Conclusion**

By reducing the cost of each part produced, your converted grinder can pay for itself in as little as six months. By reducing the cost of each part produced, your converted grinder can pay for itself in as little as six months. By reducing the cost of each part produced, your converted grinder can pay for itself in as little as six months.
Grades A500-A160

Figure 3

3M-patented Cubitron Abrasive Grain is one of the technologies that can reduce total cost of operations. Compared to conventional belts – and finish so precisely that Trizact belts can last two to five times longer than conventional belts.

Novel diamond abrasives help deliver more predictable finishes and improved, consistent belt variation. Derived from patented 3M microreplication technology – combining the unique construction allows for improved control and fewer rejects. They provide optimal performance when used for base material prep & dimensioning.

NEW 3M™ Trizact™ Diamond Cloth Disc 673W are an excellent choice for removing coating overspray and are an excellent choice for the thermal spray coatings industry. They provide optimal performance when used for base material prep & dimensioning. They are easy to use, they are low in cost and offer improved finish consistency and ease of use. Available in grades A500 to A6 in belts up to 26” wide.

NEW 3M™ Trizact™ Diamond Cloth Belts 663FC belts cut up to 70% faster than bonded wheels. They are ideally suited for stripping chrome from old parts as well as abrasion and heat resistant materials to final dimension, achieving required finishes <2 Ra. They provide optimal performance when used for centerless grinding and finishing applications except those requiring the finest possible superfinishing time in half or more. 3M™ Trizact™ Diamond Cloth Belts 663FC are designed for use on materials harder than 7 on Mohs scale (800 Knoop). Compared to bonded wheels, they offer a highly uniform polyester film backing for a more consistent, even burn through. The 663FC is a metal bond securely anchors micron-graded diamond abrasives, 3M Diamond Cloth Discs 673W deliver improved finishes and improved final part size consistency.

NEW 3M™ Trizact™ Diamond Cloth Discs 673W are available in 0.1 - 30 micron grades. 661X film has a 3 mil polyester backing, and is available in 9 - 165 micron grades. 662X film has a 6 mil polyester backing, and is available in 0.5 - 0.7 micron grades. 663X film has a 12 mil polyester backing, and is available in 0.25 - 0.3 micron grades. 664X film has a 25 mil polyester backing, and is available in 0.05 - 0.125 micron grades. 665X film has a 50 mil polyester backing, and is available in 0.025 - 0.05 micron grades. 666X film has a 100 mil polyester backing, and is available in 0.0125 - 0.025 micron grades. 667X film has a 150 mil polyester backing, and is available in 0.01 micron grades. 673W are designed for use on materials harder than 7 on Mohs scale (800 Knoop). Compared to bonded wheels, they provide optimal performance when used for centerless grinding and finishing applications except those requiring the finest possible superfinishing time in half or more. They deliver improved finishes and improved final part size consistency. A 20% higher belt cut rate than bonded wheels. And because they are easy to use, they are low in cost and offer improved finish consistency and ease of use. Available in grades A500 to A6, in belts up to 26” wide.
Today’s abrasives — for processing today’s new materials

### 3M™ Trizact™ Abrasives

Derived from patented 3M microreplication technology, Trizact abrasives start sharp and stay sharp, resulting in faster, more consistent cutting throughout the life of the belt. Fresh, sharp mineral is constantly exposed to the workpiece, containing multiple layers of mineral. As these structures wear, the three-dimensional structures of 3M abrasive technology — combining the predictable, consistent cut and finish performance of conventional abrasive products with the cutting ability of superabrasives — are exposed throughout the life of the belt.

#### 3M™ Cloth Belt 663FC

- Easy to use, even less-experienced operators can achieve predictable, consistent cut and finish performance on stainless, non-ferrous metal, and furnace heating applications.
- The macroreplicated abrasive structure of 953FA belts results in a durable cloth backing. Designed for grinding hard metals, exotic alloys and composites, they combine polishing hard to grind materials such as carbide, ceramics, and hardened metals.
- 1,000 belts in 150 grade stock removal throughout the life of the belt.
- 953FA belts cut up to 70% faster than bonded abrasive wheels with the speed, predictable dimensioning technology — combining the predictable, consistent cut and finish performance of conventional abrasive products with the cutting ability of superabrasives — are exposed throughout the life of the belt.
- 663FC belts also work well for stock removal through final finishing in wet applications. The product delivers improved finishes and improved final part size consistency.

#### 3M™ Cubitron™ Abrasive Grain

- Very predictable, consistent cut and finish performance on stainless, non-ferrous metal, and furnace heating applications.
- Flexible Diamond Belts help prevent chatter and other grinding defects on lightweight/thin-walled components.
- The macroreplicated abrasive structure of 953FA belts results in a durable cloth backing. Designed for grinding hard metals, exotic alloys and composites
- 1,000 belts in 150 grade stock removal throughout the life of the belt.
- 953FA belts cut up to 70% faster than bonded abrasive wheels with the speed, predictable dimensioning technology — combining the predictable, consistent cut and finish performance of conventional abrasive products with the cutting ability of superabrasives — are exposed throughout the life of the belt.
- 663FC belts also work well for stock removal through final finishing in wet applications. The product delivers improved finishes and improved final part size consistency.

#### 3M™ Diamond Cloth

- 3M Diamond Cloth Discs are designed specifically for centerless grinding and finishing operations. The product delivers improved finishes and improved final part size consistency.
- 3M™ Resin Bond Superabrasive Wheels

#### 3M Flexible Diamond Rolls & Belts

- Used in many applications to “roughen up” parts to a selected surface finish. Flexible Diamond Rolls can be used to deliver the “heights” and “roughness” required by some applications.
- Long-lasting and cost-effective. Micron graded diamond particles encapsulated in a ceramic bead and resin bonded to a durable cloth backing. Designed for use on materials harder than 400 hardness number of Rockwell hardness scale, and for materials where aluminum oxide would not be effective.
- AVAILABLE IN 0.1 - 30 MICRON GRADES.
Today’s abrasives — for processing today’s new materials

3M™ Trizact™ Abrasives
Conventional abrasives start out sharp, but dull quickly. They sacrifice cut rates on hard-to-grind roll materials. A metal bond securely anchors micron-graded diamond particles to a durable, stronger polyester backing. This combination provides durability and long life, while allowing conformance to a variety of contours. The open dot pattern produces aggressive cutting action and reduces grinding loads.

3M™ Trizact™ Cloth Belt 966F
966F belts have micro-technical performance advantages in finishing operations at high speeds. They are an ideal choice for refurbishment process. 966F belts are ideally suited for stripping chrome from old parts as they are being rebuilt. 966F belts are also suited for wet grinding applications except those requiring oil to gain a more effective cut. 966F belts have proven to be an ideal choice for wet grinding as they can also be run dry. Compared to conventional abrasives, 3M Diamond Polishing Belts and conventional abrasives, 3M Diamond Polishing Belts can reduce process time with fewer steps and excellent surface finishes on non-ferrous metal. The water-resistant backing performs well in both wet and dry applications. And the products' overall toughness makes them ideal for many hard-to-finish materials, including thermal spray coating during the refurbishment process. The water-resistant backing performs well in both wet and dry applications. The products' overall toughness makes them ideal for many hard-to-finish materials, including thermal spray coating during the refurbishment process.

3M™ Trizact™ Cloth Belt 953FA
3M™ Trizact™ Cloth Belt 953FA is the “next generation” in finishing technology. Developed to answer customers’ demands for improved part-to-part size consistency and performance, it delivers superior results through its non-woven, three-dimensional structure. In medium applications such as coarse stock removal, it delivers a faster, more consistent cut. In fine finish applications, it provides an excellent form retention as part of a precision grinding system.

3M™ Trizact™ Diamond Cloth Disc 972W
3M™ Trizact™ Diamond Cloth Disc 972W is designed for fine finishing for a variety of materials, providing a faster, more consistent cut. In medium applications such as coarse stock removal, it delivers a faster, more consistent cut. In fine finish applications, it provides an excellent form retention as part of a precision grinding system.

3M™ Trizact™ Diamond Cloth Disc 972M
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3M™ Trizact Abrasives

3M™ Trizact™ Abrasives are designed for the "next generation" in abrasive technology. Trizact belts feature a new 3M proprietary abrasive technology that gives you maximized performance and longer belt life.

The uniform dot pattern is engineered to reduce chatter and other grinding defects on lightweight/thin- and long parts.

The following products are included in this new "next generation" Trizact line:

- 3M™ Trizact™ Cubitron II™ Abrasive Grain
- 3M™ Trizact™ Diamond Cloth Disc 673W
- 3M™ Trizact™ Diamond Cloth 675L
- 3M™ Trizact™ Cloth Belt 683FA
- 3M™ Flexible Diamond Belts
- 3M™ Cloth Belt 683F
- 3M™ Quicksand Cloth Belts
- 3M™ Flexible Diamond Belts
- 3M™ Cloth Belt 683F
- 3M™ Quicksand Cloth Belts

Today's abrasives — for processing today's new materials

3M Abrasive Technologies

3M Abrasive Technologies has introduced a wide range of new abrasive products for diverse applications. These new products are designed to improve productivity and efficiency while delivering superior results.

New products include:

- 3M™ Trizact™ Cubitron II™ Abrasive Grain
- 3M™ Trizact™ Diamond Cloth Disc 673W
- 3M™ Trizact™ Diamond Cloth 675L
- 3M™ Trizact™ Cloth Belt 683FA
- 3M™ Flexible Diamond Belts
- 3M™ Cloth Belt 683F
- 3M™ Quicksand Cloth Belts

These new products are engineered to provide superior performance and longer belt life, resulting in faster, more consistent cutting throughout the life of the belt.

For more information on these new products and their applications, please visit the 3M Abrasive Technologies website.
**Process Recommendations and Expected Results**

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<th>Roll Material</th>
<th>Grade</th>
<th>Abrasive Speed</th>
<th>Traverse Rate</th>
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<tr>
<td>Nickel Based</td>
<td>A16</td>
<td>A30</td>
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<td>Chrome Oxide</td>
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<td>Aluminum Oxide</td>
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**Roll Material**
- Nickel Based
- Chrome Oxide
- Aluminum Oxide

**Grade**
- A16
- A30
- A65

**Abrasive Speed**
- 36
- 36
- 36

**Traverse Rate**
- 60
- 60
- 60

**Rmax**
- 30µ
- 40µ

**Ra**
- 0.00025
- 0.0005

**Converting Your Wheel Grinder into a High Performance Machine**
- **Step 1:** Convert your wheel grinder into a high performance machine by upgrading it with 3M Abrasive Products.
- **Step 2:** Increase the productivity and efficiency of your grinding operations.
- **Step 3:** Achieve superior surface finishes with 3M Abrasive Products.

**Life after Chrome:**
- It’s not the same old grind.
- Increase productivity and efficiency with 3M Abrasive Products for chrome grinding.

**Application Guide**
- For more details, contact your 3M Abrasive Products representative for more information.

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- 610-231-2222
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Converting your wheel grinder into a high performance machine capable of using 3M™ Abrasive Belts can help you increase production without the cost of a new machine! Now you can experience increased production, ease of use, and take full advantage of all the benefits these exciting new abrasive belts can offer. And because they cut faster and don’t require dressing, you can cut fast, efficient on many of these newer, hard-to-grind materials and meet today’s tough processing challenges. From grinding-to-finishing, 3M Abrasive Belts can help you increase production without the cost of a new machine! Contact your local 3M representative today to learn more about the benefits these exciting new technology have to offer.

Life after chrome:

Increasing productivity on the assembly line has never been easier! 3M Abrasive Belts have hardened the switch to thermal spray hard coats and other advanced materials in high performance corrosion control and wear-resistance applications.

Traditional grinding and finishing methods are proving less effective or even more costly to produce low to moderate quality finishes, slower down production and driving up costs.

Now 3M brings you a range of advanced diamond-coated grinding wheels to handle the challenges. From grinding to finishing all the way to superfinishing, 3M provides the tools you need to achieve the best possible parts at the lowest overall cost. Compared to traditional bonded wheels and inhouse grinding, 3M’s abrasive belts are easy to learn and less dependent on operator skill. For more consistent, predictable results, the 3M Abrasive Belts are designed to enhance productivity. 3M abrasive belts can also help you produce lower overall costs without sacrificing any quality. In just a few minutes, 3M offers you technical support and application development resources – backed by 70 years of advanced experience – to help optimize your process, and take full advantage of all the benefits these exciting new technologies have to offer.